

Date: Tuesday, 7/1/2008 10:46:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: EXTRUSION "I" BEAM TUBE 4"		
Job Number	: 40150		Part Number	: D25001190		
Estimate Number	: 10154		Drawing Number	: D2500 UNDER REVIEW <i>OK QP 08.07.01</i>		
P.O. Number	:		Project Number	: N/A		
This Issue	: 7/1/2008	S.O. No. :	Drawing Revision	: G		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SKIDTUBES	Due Date	: 7/30/2008 Qty: 80 Um: Each		
Previous Run	: 37544		Comment	Est: G 02.09.05 Added DSK 066	KJ/RF	EC
Written By	:		est H 07.07.06 rev G dwg			
Checked & Approved By	:					
Comment	:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <i>61672</i> <i>C 08/07/02 80</i> a) Extrude as per Dwg D2500 b) Material: 6061-T6 (QQ-A-200/8) <i>OK ASTM B221</i> <i>QP 08.07.01</i> c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 190" long g) Bon L Canada Inc. tool # 897105 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required		

2.0	D25001190P	Ext'n - 'I' Beam Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s) EXTRUSION "I" BEAM TUBE 4"		
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3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached <i>5/08/07/17 78 HALL 63 G 15 78 TOTAL</i>		
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4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK Inspect dimensions per Dwg D2500 Check Pull test per Dwg D2500 for compliance page attached. <i>5/08/07/17 (78) counted</i>		
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 10:46:38 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTRUSION 'I' BEAM TUBE 4"

Job Number: 40150

Part Number: D25001190

Job Number:



Seq. #:

Machine Or Operation:

Description :

Check hardness with Webster tester

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: HALL 001→63

L.G+15 = TOTAL Am

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>H</i>	DRAWN BY <i>PS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2500	REV. G SHEET 1 OF 3
DATE 07.04.17		TITLE EXTRUSION	SCALE NTS
A	96.03.19	NEW ISSUE	
B	96.03.24	CHANGE INTERNAL WEB	
C	96.04.26	ADD D2500-3 WEB	
D	96.10.07	ADD MATERIAL PROPERTIES	
E	96.10.24	CHANGE MATERIAL TEMPER	
F	97.09.29	CHANGE MAT. TO 6061-T6	
G	07.04.17	ADD NOTES 3,5,6	

RELEASED
07.06.28 *H*
UNDER REVIEW
08.04.02 *HP*
FOR REV. H

1. MATERIAL: 6061-T6 (QQ-A-200/8% OR ASTM B221) *HP 08.07.01*
 MINIMUM TENSILE YIELD STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
 MINIMUM ELONGATION = 8%
 A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO
 ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY
 TO ENSURE THAT THE BATCH MEETS THE ABOVE
 MINIMUM MECHANICAL PROPERTIES
2. BREAK ALL SHARP CORNERS 0.010 MAX
3. ALL DIMENSIONS ARE IN INCHES
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH (EX. D2500-1-190 IS 190" LONG)
 D2500-1 EXTRUSION MANUFACTURED FROM:
 - A) BON L DIE # 897015 -> PREFERRED
 - B) CARADON MIDEAST DIE # PAH-28030
 - C) CARADON MTL DIE # MH-18868
6. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG)
 D2500-3 EXTRUSION MANUFACTURED FROM:
 - A) CARADON INDALEX DIE # MS-18867

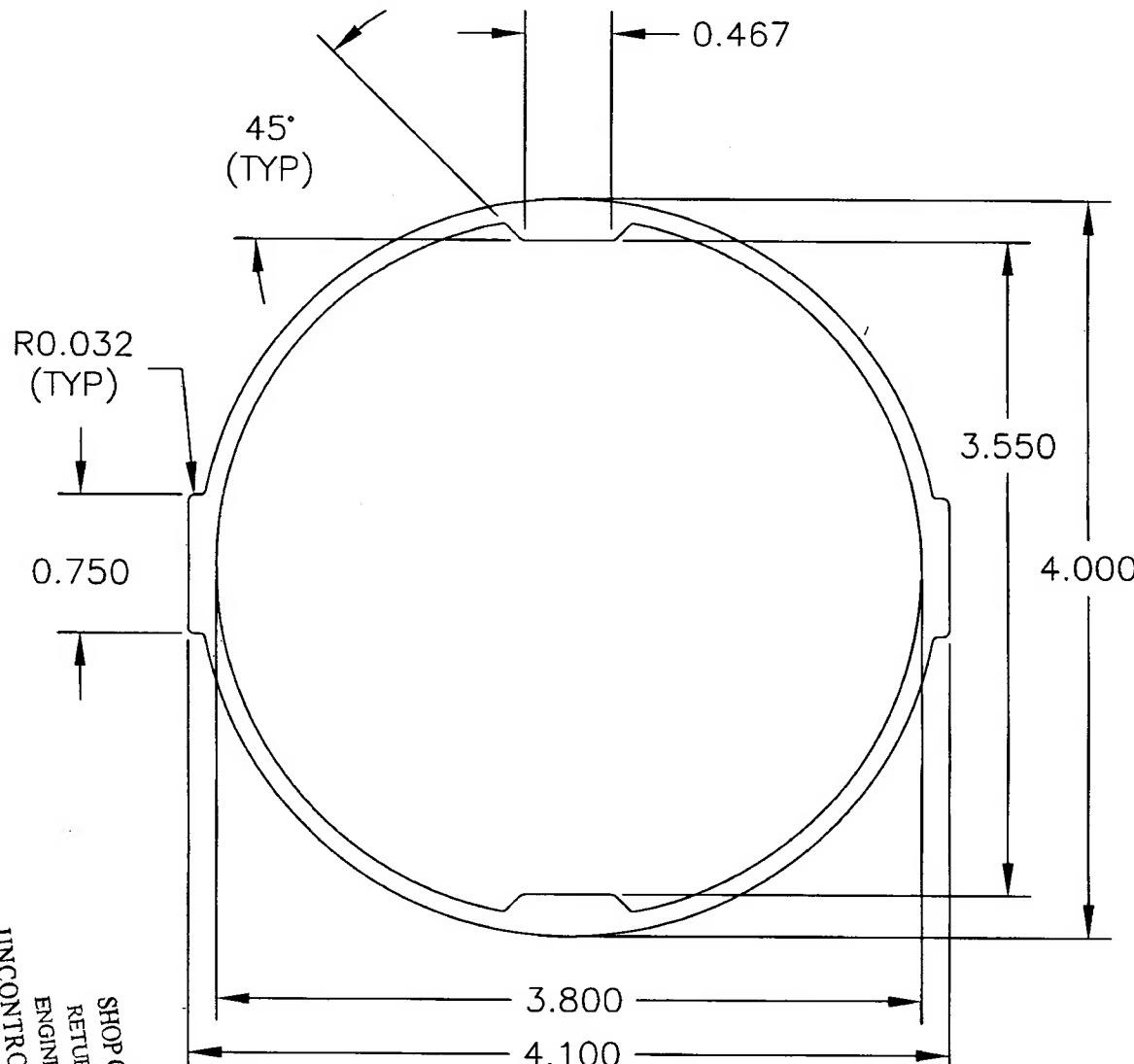
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WITHOUT NOTICE
WORK ORDER
NO. *40150*

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DART**RELEASED****UNDER REVIEW**08-04-02
FOR REV-H

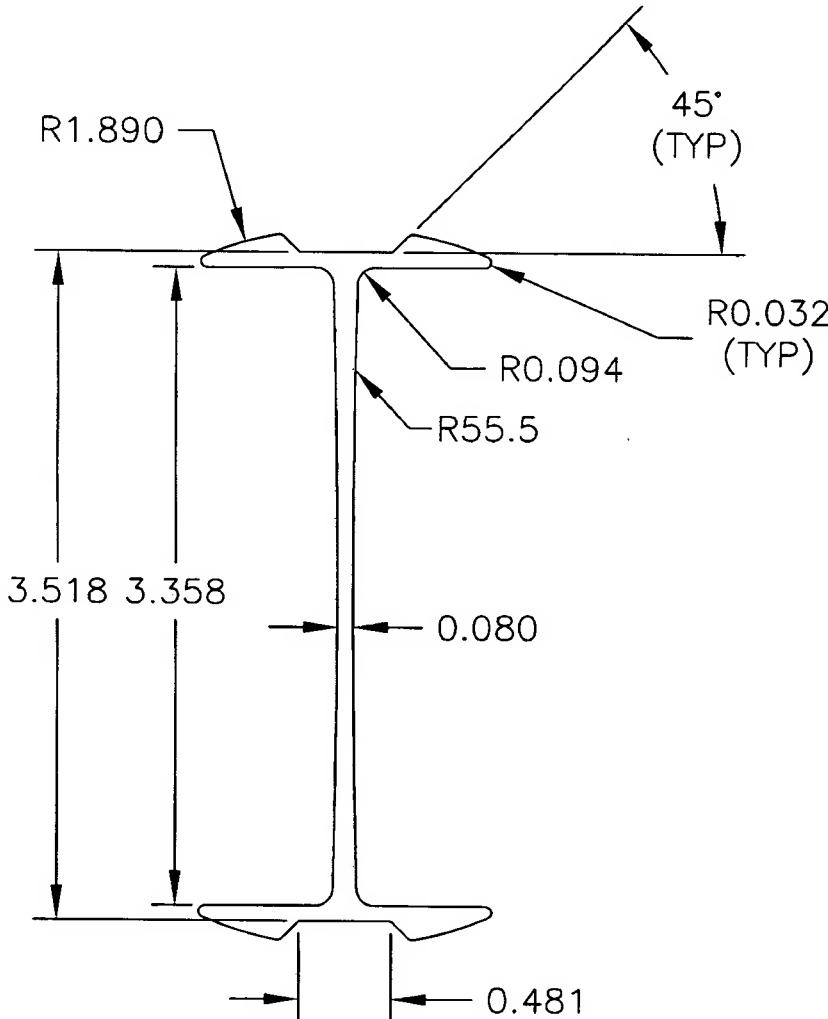
DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. G
		D2500	SHEET 2 OF 3
DATE		TITLE	SCALE
07.04.17		EXTRUSION	1:1

**D2500-1**

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DART

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PH	PH	D2500	SHEET 3 OF 3
DATE	07.04.17	TITLE	SCALE
		EXTRUSION	1:1

RELEASED**UNDER REVIEW**08-04-02
FORZ REV.H**D2500-3**

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WORK ORDER
NO. 40150



ACCT# 00046024

SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN

SOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN

PHONE 613-632-5200

PHONE 613-632-5200

INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

TERMS / FREIGHT
O / P

SHIPPING MANIFEST

MANIFEST DATE 07-15-08											
MANIFEST NUMBER	643716										
SALES ORDER NUMBER	33203										
CREDIT REP HAMBROOK, PAU 905-508-3250	SALES REP										
FIELD SALES REP Kutter A 450-435-6551	CUST SERVICE REP Burton D 905-427-2227										
BILL OF LADING NUMBER 08380474											
ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	THIS SHIPMENT	UNIT	QUANTITY DUE		
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION	NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
01	80	KG M PC	0 0 0	DAA-897105-2 D2500-1-190	6061 /T6 190" +5/16 " -0 "	MILL CERTIFICATE OF COMP (+010-010, 0088-0072)	3	1037	1003 376.43 78	KG M PC	30 10 2
				LOT/TKT DETAIL:		33203010 / 279174 33203010 / 279175 33203010 / 279176	1 1 1	425 306 306	409 297 297	32 PC 23 PC 23 PC	32 PC 23 PC 23 PC
											78
<i>SHIPPING MANIFEST</i>		PAGE	1	TOTALS	3 1037 1003 376.43 78	KG M PC					

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.



CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Gen. Date	Cert No.	Sales Order	Page
07/15/08	179032	33203	1
6672	08380474	33203010	7/15/08

Ship To	Ship To
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No.	Part No.	Item Description	Cost Part
1.000	DAA-897105-2	190" Mill 6061 T6	D2500-1-190
Gross Weight:	1037 KGS		
Net Wt.	1,003 KG	78 PC	376 M
Specification:	AMS-QQ-A-200/8 & ASTM B221-06		

Mechanical Tests:						
Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift	HREW
1	278.3 / 40.4	252.7 / 36.7	10.5	.0	94	
Chemical Analysis:						
SI	FE	CU	MN	MG	CR	ZN
.64	.26	.27	.06	.88	.06	.03
						.02

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc